

Date: Tuesday, 11/29/2005 6:50:52 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 25038		
Estimate Number	: 10911		
P.O. Number	: N/A	Part Number	: D3405041
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D3405 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE ABOVE DATE & USER</u>	Due Date	: 12/21/2005 Qty: 10 Um: Each
Checked & Approved By	: <u>SEE ABOVE DATE & USER.</u>		
Comment	: Created By Auto Work Order		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 00000186 8/05/11/30

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3405

Material release note is required

Identify as D3405-1

10

Tools:

2.0 D34051F

GHW Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

G H W BRACKET

Tools:

3.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

0206/10/105 10

Tools:

4.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3405

06-01-17 10

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 25038

Part Number: D3405041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr SAB 06:01:22

Form using DT8204 as per Dwg D3405

SAB 06/02/07

Tools:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-07

Tools:

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B28118

A/R

SS Rod

M18712

CPL 06-02-09 (10)

Tools:

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

CPL 06-02-09 (10)

Tools:

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

NA 06/02/09

Tools:

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

arm 06-02-11

Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA

06 02 13

Tools:

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 577

06/2/13 (10)

Tools:

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

505 06/02/14

(10)

17 06/02/14 (10)

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



燐茂實業股份有限公司

YIEH MAU CORP.

INVOICE NO. :

F05M325R

COMMODITY :

PRIME COLD ROLLED STAINLESS STEEL SHEET

MATERIAL TEST/INSPECTION CERTIFICATE

98264027

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIAO
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972886 FAX:(07)6973006
CERTIFICATE NO: F05M325R
DATE OF ISSUE:03/31/2006
PAGE:3

SPECIFICATION :

AISI 304

CUSTOMER :

INTEGRIS METALS LTD

SIZE	BUYER'S ITEM NUMBER	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)								
			KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304 2B																				
11GA / 48" X 120"	(7427-6445)	1	1,404	3,095	YU136029	42S56953A-2122	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 120"	(7427-6445)	1	1,051	2,317	YU136029	42S56953A-2123	275	630	51	83	164	4.1	52	109	31	3	820	1817	2.4	
11GA / 48" X 96"	(7427-6403)	1	1,398	3,082	YU136785	42S60093B-11	290	659	51	84	169	4.3	47	119	28	9	809	1827	2.9	
AISI 304 NO.4																				
16GA / 36" X 120"	(7426-6064)	1	1,396	3,078	YU232680	41S56329-22111	300	670	50	82	159	4.7	50	122	25	9	805	1813	2.9	

4 5,249 11,572

Remarks:

NO MERCURY CONTAMINATION

Bend test: good for all Heat NO.

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS

BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,

A262E, ASME SA240, Q3766D.

P.O. NO.: 494470

YIEH MAU CORP.

Manager of Quality Assurance Section

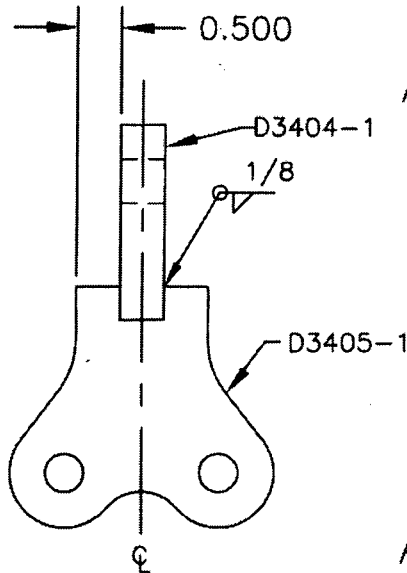
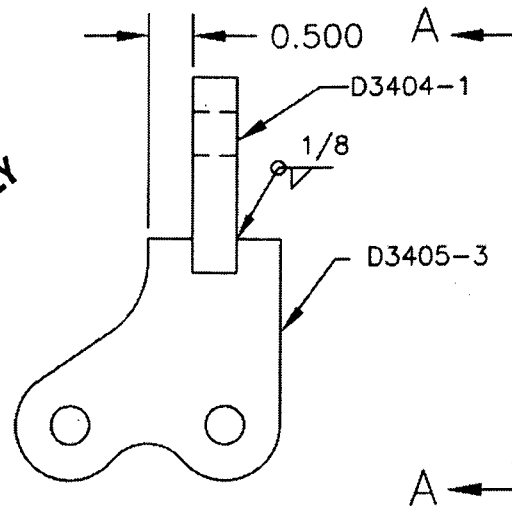
11 ga 304 2B SS

206.0117

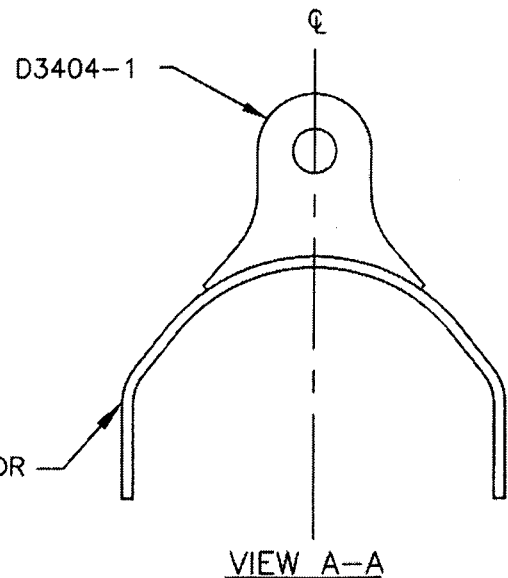
100# 186, 215, 146, 248, 245

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

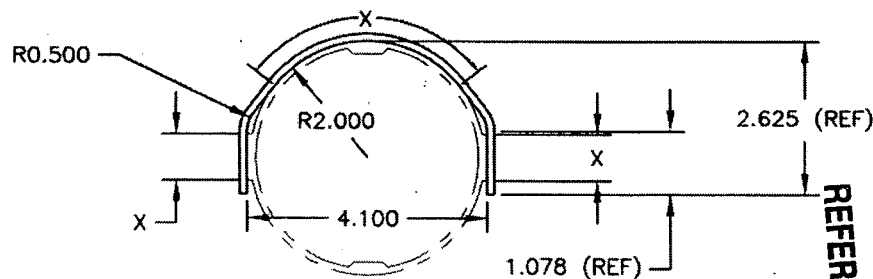
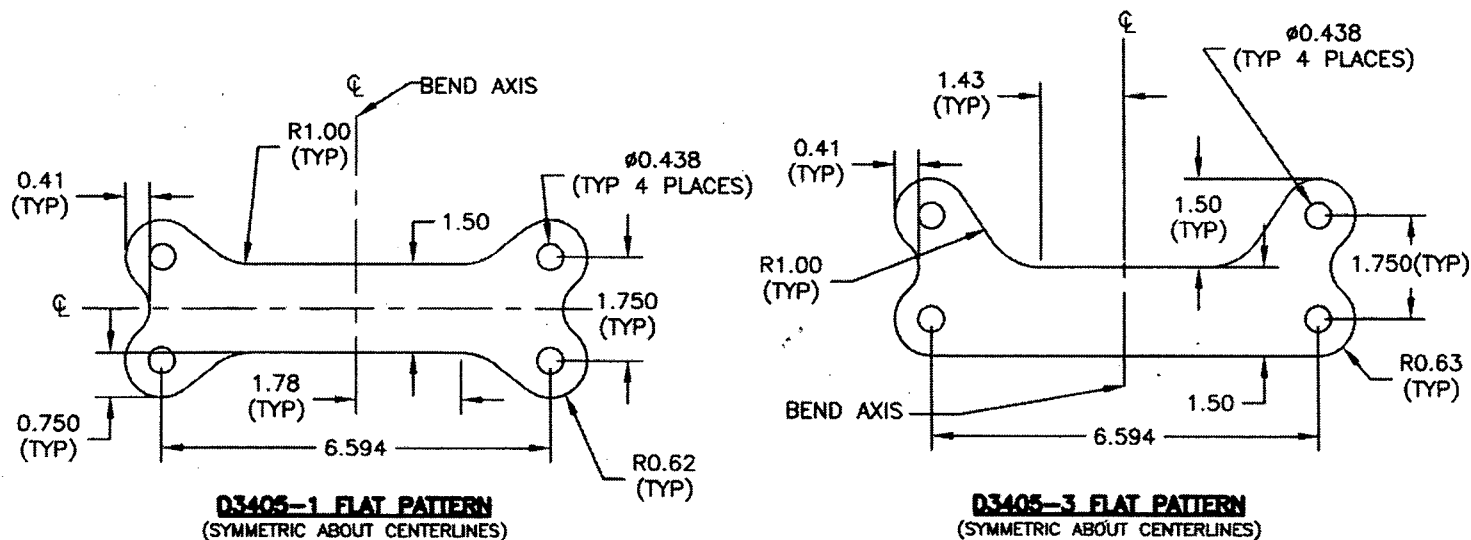
RELEASED
05 08-09 HD3405-1 OR
D3405-3**D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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DART



D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

REFERENCE ONLY

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3

RELEASED
05.08.09